

Work Order ID 111866

Thursday, January 23, 2014 4:12:21 PM

111866

Page 1

Item ID: D4634-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Middle, Center Ceiling Panel Assembly
Start Date: 1/23/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/29/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: P Date: 11-01-23 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4634	E								

100		0.00							
100									
Hand Thermo	Memo	0.00							
Hand Finishing Thermoforming	Pick Kit								

110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per Dwg D4634-043								
	2- Install led lights								
	3- Install Air valves								
	4- Install wiring harness								

① SMO 11/01/23

① SMO 11/01/28

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120		27				1			
QC	Memo	0.00							
Quality Control		14/1/29							
130	Identify as per dwg & Stock Location: <i>fig</i>	0.00							
130							W		
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

W 14.01.29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 1

Work Order ID: 111866

111866

Parent Item: D4634-043

D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 1/23/2014

Required Date: 1/29/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
 12/11/08 Doc Release DL VERIFIED BY:JLM IPP Rev C Dwg Update
 13/07/09 DL verf: DD IPP Rev. D Dwg Update 13/12/23
 DL IPP REV E Dwg Update 14/01/20 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4634-143		Manufactured	No			100	Each	0.0000	1	1			
D4634-143													
Middle, Center Ceiling Replacement Panel Assembly													
D4646-1		Manufactured	No			100	Each	60.0000	2	2			
D4646-1													
Plenum Cap Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST116				60					
				103832				60					
D4652-1		Manufactured	No			100	Each	191.0000	2	2			
D4652-1													
Air Valve, 1.16 Id Disk Type													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST099				191					
				111311				191					
D4728-053		Manufactured	No			100	Each	1.0000	1	1			
D4728-053													
Cabin Lights #2													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST121				1					
				111205				1					

Picklist Print

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Parent Item: D4634-043

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Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 1/23/2014

Required Date: 1/29/2014

Start Qty: 1.00

Required Qty: 1.00

PLT1.5M-M

Purchased

No

100

Each

945.0000

3

3

PI T1 5M-M

Tie Wrap

**

SAD 14/01/28

Location

Loc Qty

Loc Code

ST389

945

124363

2

m126551

943

2351-20-27-C3C

Purchased

No

100

Each

72.0000

2

2

2351-20-27-C3C

STUD

**

SAD 14/01/28

Location

Loc Qty

Loc Code

ST396

72

m126740

30

m127922

42

50-009-2

Purchased

No

100

Each

83.0000

2

2

50-009-2

Grommet

**

SAD 14/01/28

Location

Loc Qty

Loc Code

ST378

83

122594

1

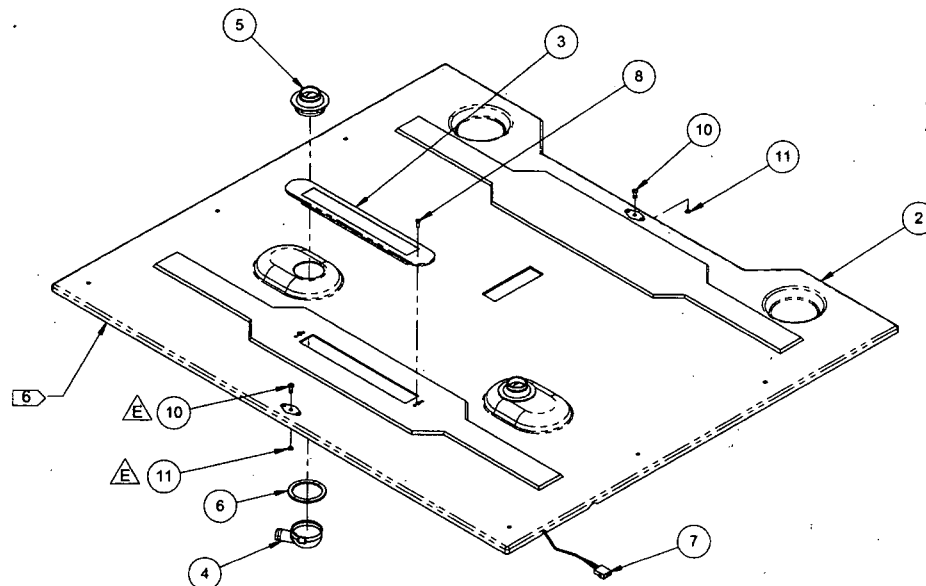
m128022

82

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Shop Packet Print

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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-051)
4	2	D4646-1	PLENUM CAP ASSEMBLY
5	2	D4652-1	AIR VALVE
E 6	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
7	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
8	2	N/A (REF)	SCREW (PART OF D4728-053)
9	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
E 10	2	2351-20-27-C3C	STUD
E 11	2	50-009-2	GROMMET

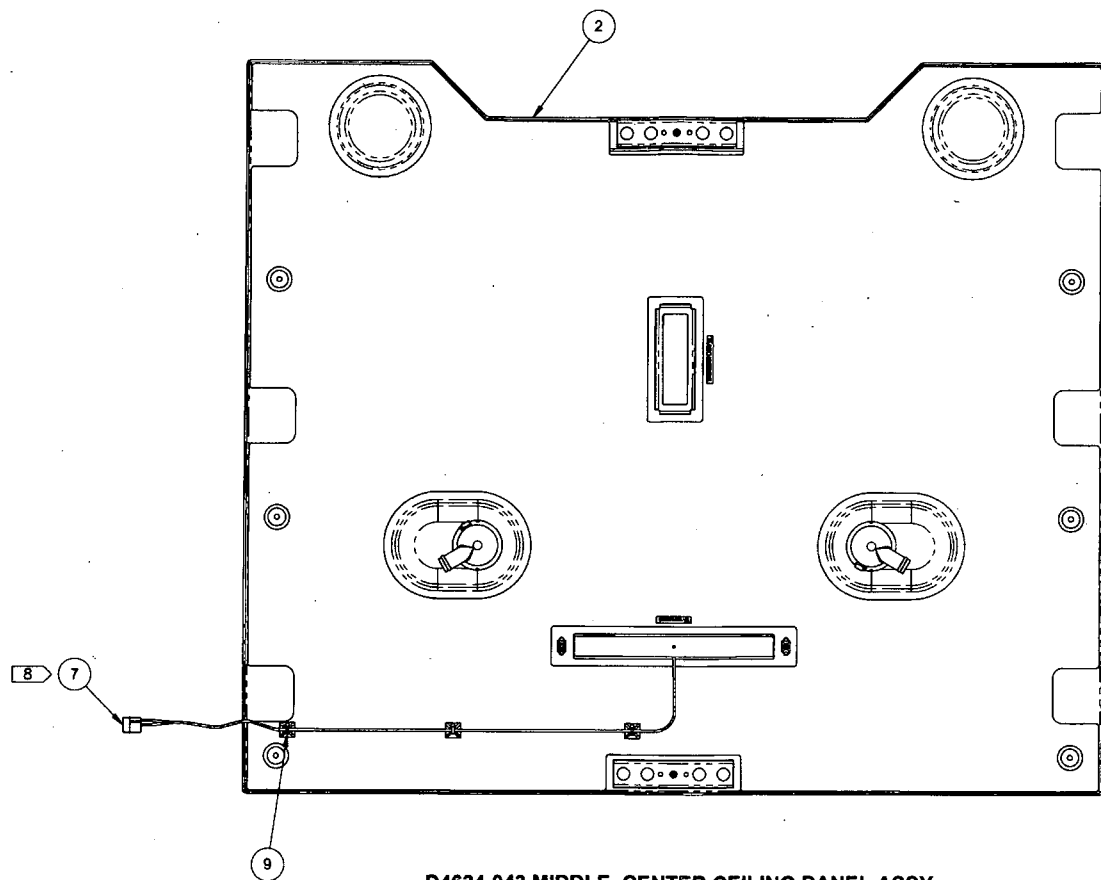
111864
2012-01-23

D4634-043 MIDDLE, CENTER CEILING PANEL ASSY

RELEASE
2014-01-22

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
 - 7) WEIGHT: 9.5 lbs
 - 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

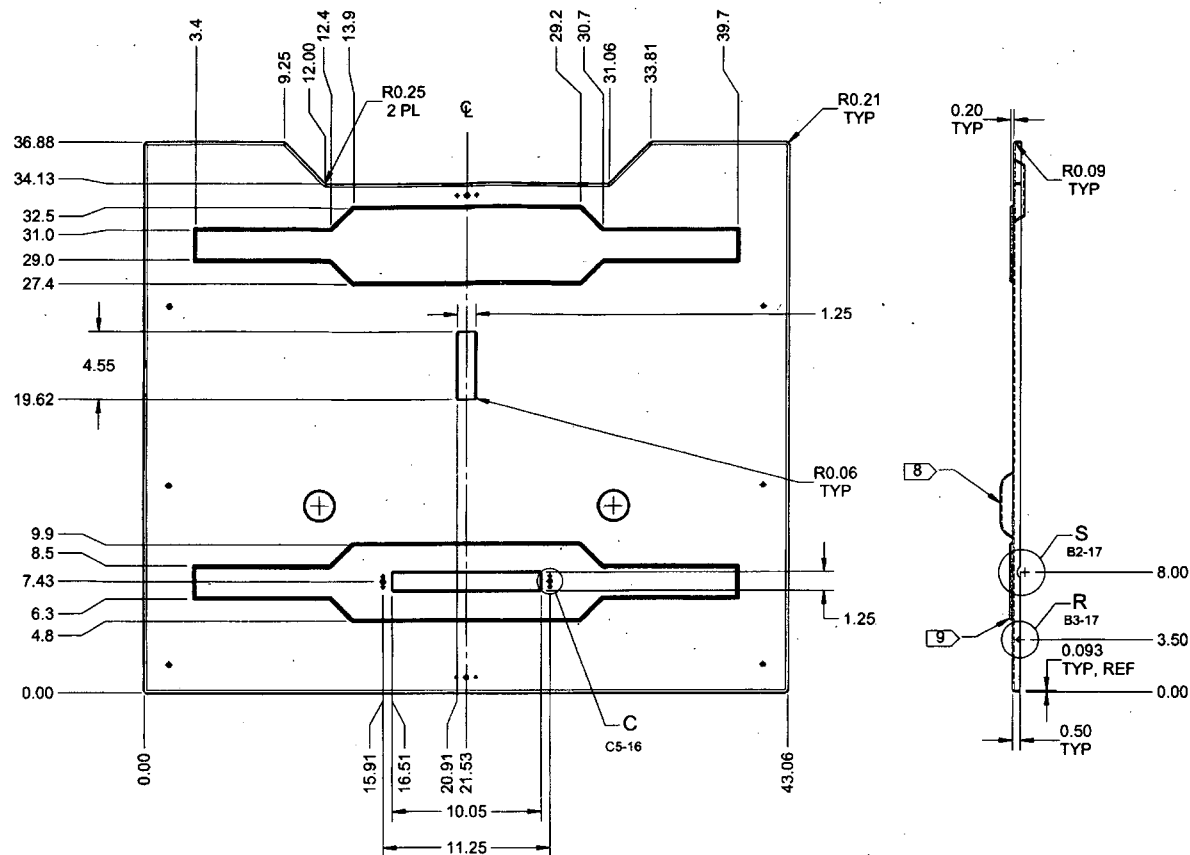
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.	BC	D4634	SHEET 3 OF 17
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CENTER CEILING PANELS	NTS
DATE	14.01.09	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



D4634-043 MIDDLE, CENTER CEILING PANEL ASSY
AUXILIARY VIEW

RELEASED
2014-01-22

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.	BC	D4634	SHEET 4 OF 17
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CENTER CEILING PANELS	NTS
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NOTES:

1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 6.49 lbs

8) TEXTURE ON THIS SIDE

9) 0.14 RADIUS NOT SHOWN FOR CLARITY

10) DRILL & TRIM D4634-3 PER TOOL DT9837

11) THERMOFORM PER QSI 022 USING DT9845 TOOL

MIN. THICKNESS AFTER FORMING:

EDGES = 0.060

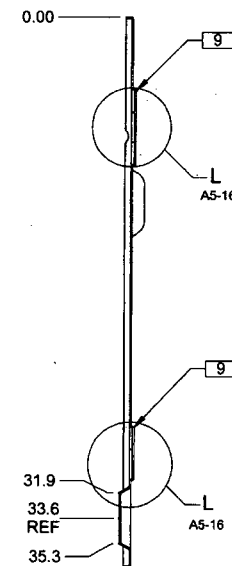
ELSEWHERE = 0.070

12) LOCATE $\varnothing 2.030$ AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-3 MIDDLE, CENTER CEILING PANEL

RELEASED
2014-01-22

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	PC	D4634	SHEET 12 OF 17
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	CENTER CEILING PANELS	NTS
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D4634-3 MIDDLE, CENTER CEILING PANEL
AUXILIARY VIEW

2014-01-22

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>BC</i>	D4634	SHEET 13 OF 17
APPROVED	<i>BC</i>	TITLE	SCALE
DE APPR.	<i>BC</i>	CENTER CEILING PANELS	
DATE	14.01.09	NTS	

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